

SKP 22/01

# Work Order ID 55349

January 13, 2010 12:34:25 PM



Item ID: D3371-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Base

Start Date: 1/13/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3371	Rev B

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.00" x 2.25" x 7.370" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine D3371-1 as per Folio FA486 and Dwg D3371-1 Deburr! Finish 8-32 thread by hand! Identify as D3371-1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-1 PAR #: N/A Fault Category: MACHINE NCR: Yes No DQA: H Date: 10.01.21  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: H Date: 10/01/26

NCR: 55349		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/15	#110	Part has Dim. 101 too thin measure 0.080". R.C. Part moved in saws/usc Power	10.01.15	- Make correct saws. - ACCEPTABLE DEVIATION THIS BATCH ONLY	SB 10/01/15	10.10.15	10.01.15 P. 10.10.15	8 10/01/15
10/1/15	#110	Marks in part Due to Roughen R.C. Process	10.01.15	- ACCEPTABLE	SB 10/01/15	10.10.15	10.01.15 P. 10.10.15	8 10/01/15
10/1/15	#100	Qty 2 parts Are too Short 7.19" measure 7.13". R.C. moved in saw	10.01.15	- Make correct tooling. - Scrap + Destroy + Replace MA 16427 Parts used	SB 10/01/15	10.10.15	10.01.15 P. 10.10.15	8 10/01/15

NOTE: Date & initial all entries

# Work Order ID 55349

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Item ID: D3371-1

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Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date:

Tooling: Date:

Stop

QC: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

10.10.15

6 2

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-01-18

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

BR 10-01-20  
10-01-18

QC

Memo

0.00

Quality Control

Pto

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/01/18	145	Powder coat Red as per dwg (perm. change) Batch: <u>M102391</u> Start time: <u>10:00AM</u> Oven temp: <u>320°F</u> Finish time: <u>10:30AM</u>	AA	10-01-18			S 10/01/20	
			dl	10-01-20	(X6)		S 10/01/20	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 55349

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Page 3

Item ID: D3371-1

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Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Base

Start Date: 1/13/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

10-1-20

(6x) 31

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/20

MF  
10-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 13, 2010 12:34:24 PM

Page 1

Work Order ID: 55349

Parent Item: D3371-1

Parent Item Name: Pedal Lock Base

Start Date: 1/13/10

Required Date: 1/22/10

Comments: IPP A 05.01.18 New issue: KJ/JLM.

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	20.7105	3.9474			



6061-T6 Bar 2.00 x 2.25

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

20.7105

16427

20.7105

3.9474

LF 10/01/14

+ 2 parts scrap same Batch 16427

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Pedal Lock Base		<b>Part Number:</b>	D3371-1
<b>Inspection Dwg:</b> D3371 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
         
 ☐ **Prototype**

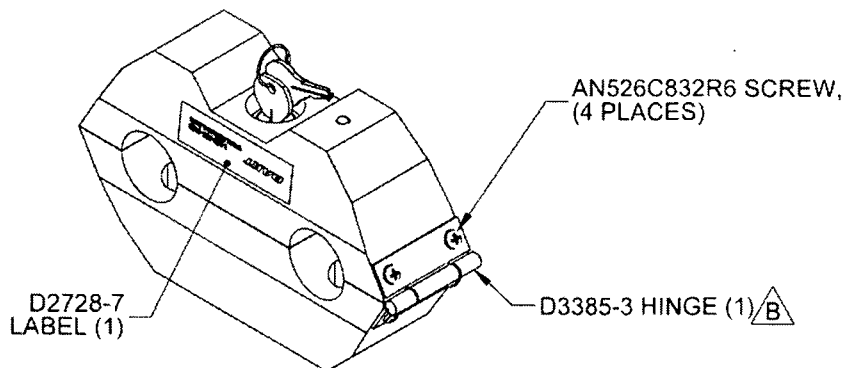
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.237	✓			
1.650	+/-0.010	1.648	✓			
1.648	+/-0.010	1.645	✓			
0.700	+/-0.010	.700	✓			
3.955	+/-0.010	3.956	✓			
0.600	+/-0.010	.603	✓			
0.104	+/-0.010	.098	✓			
0.305	+/-0.010	.311	✓			
45°	+/-0.5°	45°	✓			
0.672	+/-0.010	.680	✓			
Ø1.300	+/-0.010	1.295	✓			
1.450	+/-0.005	1.448	✓			
7°	+/-0.5°	7°				
2.00	+/-0.030	1.995	✓			
1.125	+/-0.010	1.128	✓			
Ø1.125	+/-0.010	1.128	✓			
R0.500	+/-0.010	.500	✓			
1.000	+/-0.010	.995	✓			
0.375	+/-0.010	.368	✓			
Ø0.203	+0.005/-0.000	.206	✓			
7.19	+/-0.030	7.197	✓			
4.500	+/-0.010	4.500	✓			
0.500	+/-0.010	.500				

<b>Measured by:</b> <i>LF</i> <b>Date:</b> 10/01/15	<b>Audited by:</b> <i>ML</i> <b>Date:</b> 10.10.15	<b>Prototype Approval:</b> N/A <b>Date:</b> N/A
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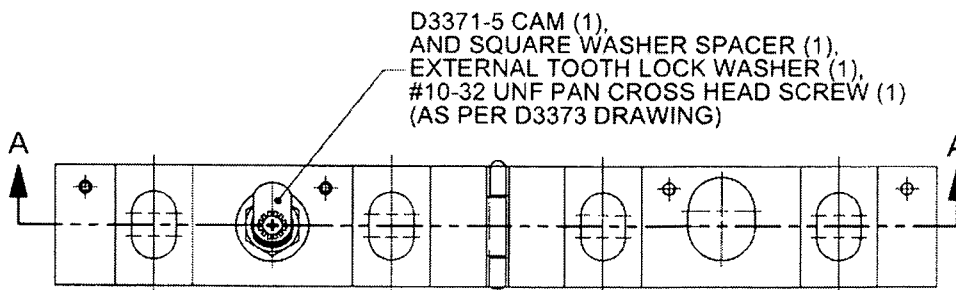
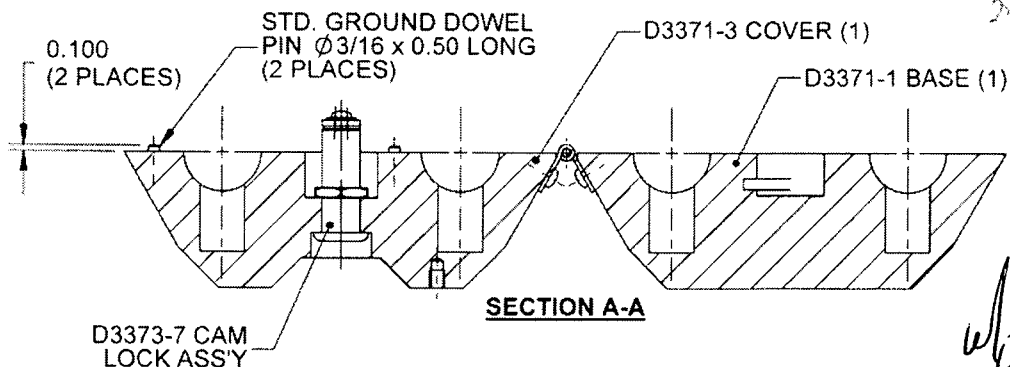
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM <i>KA</i>	<i>KA</i>



DESIGN 10	DRAWN BY 10	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED 17	DRAWING NO. <b>D3371</b>	REV. B SHEET 1 OF 4
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



**PEDAL LOCK SHOWN LOCKED WITH KEY**



**D3371-051 PEDAL LOCK ASSEMBLY**

**NOTES:**

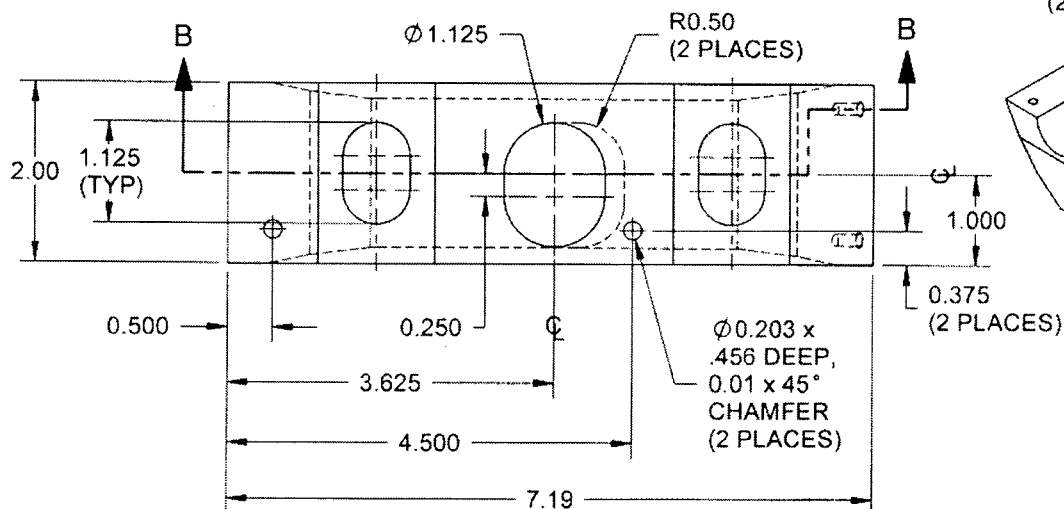
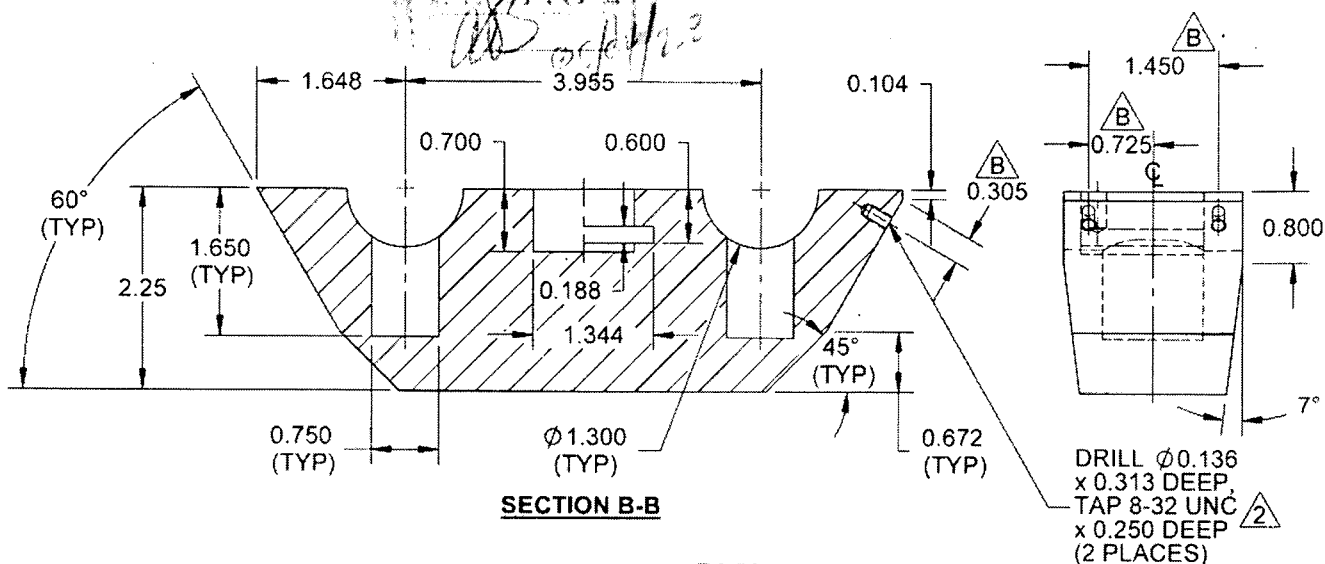
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 2 OF 4
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2



### D3371-1 BASE

#### NOTES:

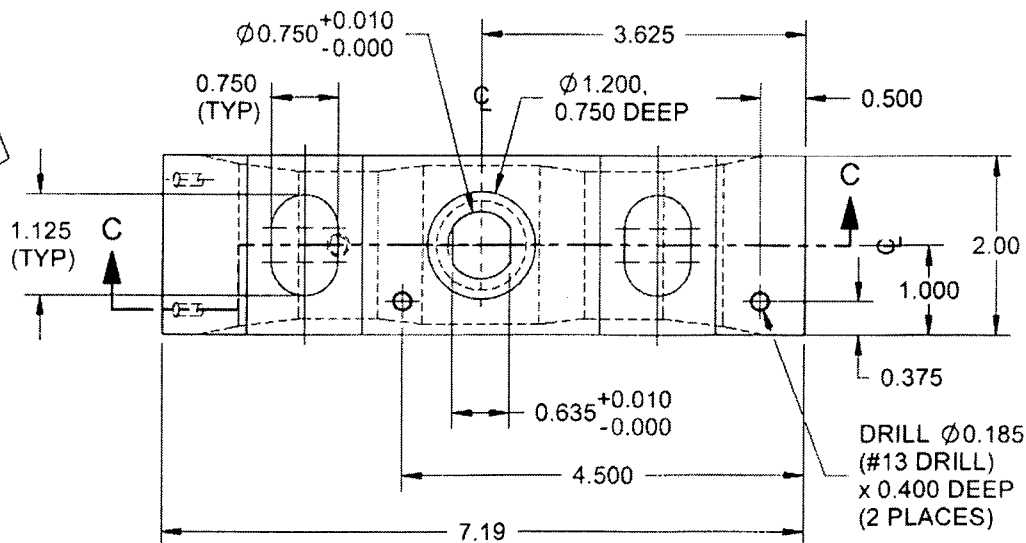
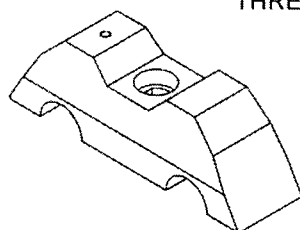
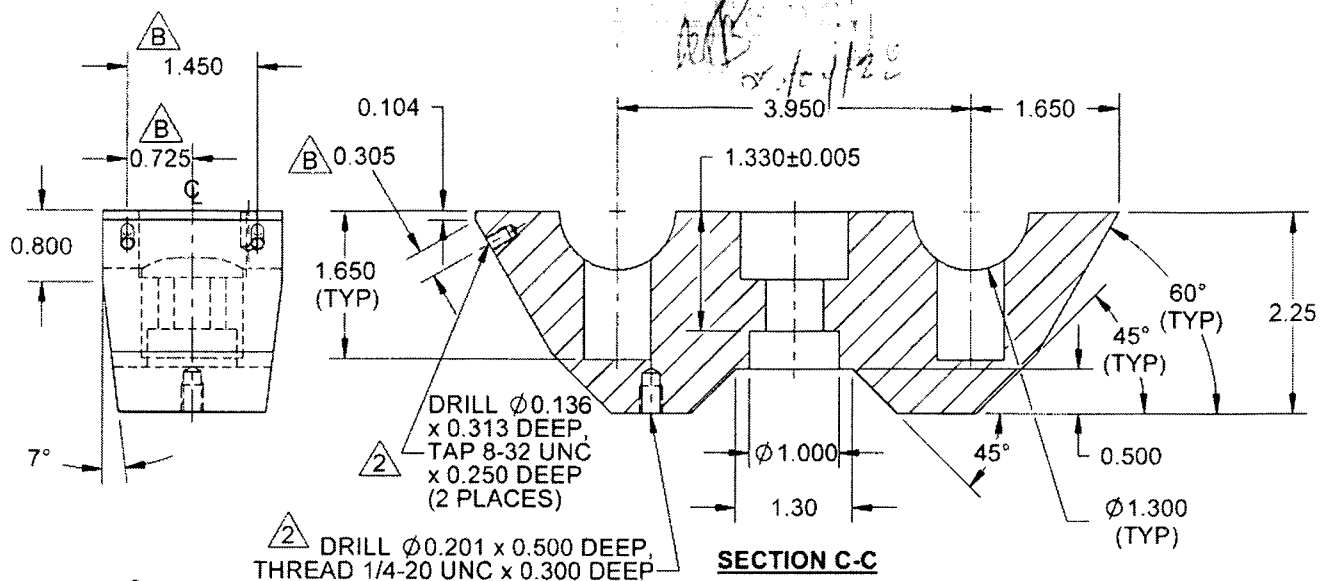
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 3 OF 4
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2



#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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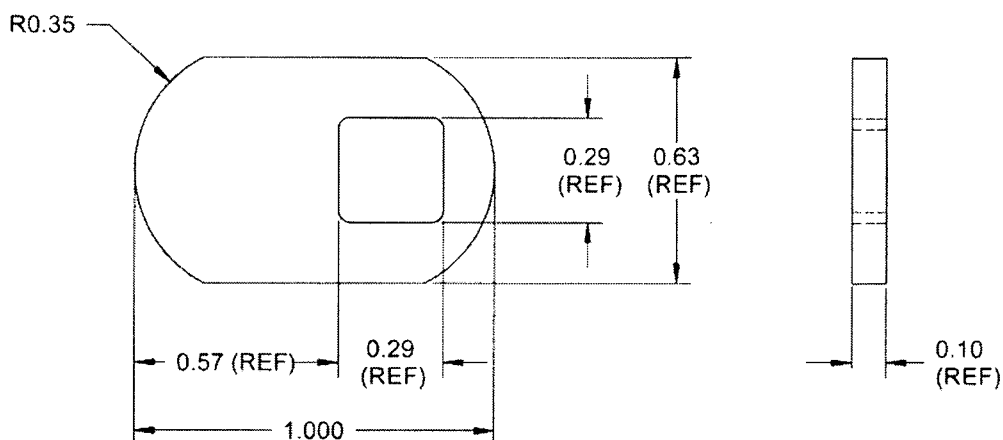
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 2:1

*05/04/22*

## SPECIFICATION CONTROL DRAWING



### D3371-5 CAM

#### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
  - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- wld 5/3/29*

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